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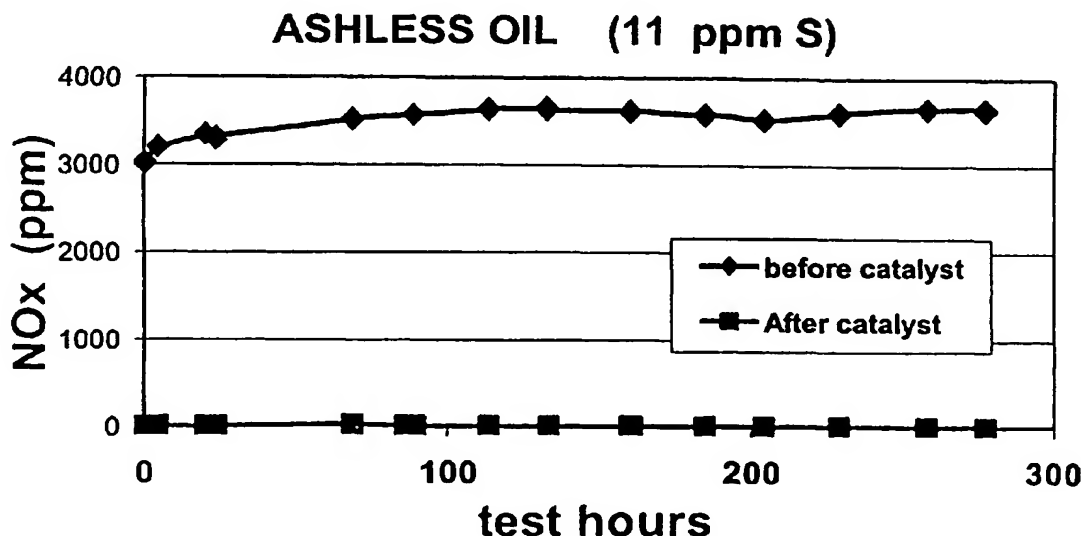
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(54) Title: A LOW-SULFUR CONSUMABLE LUBRICATING OIL COMPOSITION AND A METHOD OF OPERATING AN INTERNAL COMBUSTION ENGINE USING THE SAME



(57) Abstract: A consumable lubricating oil composition, comprises a base oil and an acylated nitrogen-containing compound. It has a sulfur content of 5 to 250 ppm and is characterized by the absence of an extreme-pressure additive comprised of metal and phosphorus. This composition can be used for lubricating an internal combustion engine equipped with an exhaust gas aftertreatment device, by removing part of the lubricating oil composition from said engine and combining it with fuel which is consumed as the engine is operated, or combining it with the exhaust gas from the engine.

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**TITLE:**

A LOW-SULFUR CONSUMABLE LUBRICATING OIL COMPOSITION AND A METHOD OF OPERATING AN INTERNAL COMBUSTION ENGINE USING THE SAME

This application is a continuation-in-part of the United States Patent Application filed on December 1, 2000 under U.S. Express Mail Label No. EF297166726US entitled "A Low-Sulfur Consumable Lubricating Oil Composition and a Method of Operating an Internal Combustion Engine Using the Same" in the name of William Bricker Chamberlin, III, et al. (attorney docket number 3049) and a continuation-in-part of U.S. Application Serial No. 09/664,834 filed September 19, 2000. The disclosures in these prior applications are incorporated herein by reference in their entireties.

**Technical Field**

This invention relates to low-sulfur consumable lubricating oil compositions and to a method of operating an internal combustion engine using the same. The inventive method provides the advantage of extending required time intervals between oil changes and reducing NO<sub>x</sub> levels in exhaust gases.

**Background of the Invention**

A problem associated with internal combustion engines equipped with exhaust gas aftertreatment devices (e.g., catalytic converters, particulate traps, catalyzed traps, etc.) is that the lubricating oils for such engines are used in both the crankcase as well as in high wear areas such as the valve train. Because these oils are used in high wear areas they usually contain extreme pressure (EP) agents which typically contain metal (e.g., zinc) and phosphorus in order to be effective. During the operation of the engine these EP agents decompose and the resulting decomposition products eventually enter the aftertreatment device resulting in damage to the device. The problem therefore is to provide a lubricating oil composition that avoids damaging the exhaust gas aftertreatment device.

Another problem associated with conventional internal combustion engines is that the time interval required between oil changes typically is less than the time interval required for other service items such as air filter replacements, coolant changes, brake replacements, and the like. Oil changes are viewed as one of the

most aggravating and, in some cases, most costly maintenance aspects of vehicle ownership. Traditionally, oil change intervals have been extended by base stock and additive upgrades. Since the 1920s, for example, the extensions have been about 15X or greater. Regardless of this progress, the time intervals required between oil changes continue to lag behind the time intervals required for other service items. The problem therefore is to improve the lubricant technology for these engines so that the time intervals between oil changes can be extended to coincide with other service intervals.

Another problem associated with the operation of internal combustion engines is that the exhaust gases from such engines contain  $\text{NO}_x$  which is an undesirable pollutant. It would be advantageous if the level of  $\text{NO}_x$  in the exhaust gases of internal combustion engines could be reduced.

The present invention provides a solution to each of these problems. With the present invention low-sulfur consumable lubricating oil compositions characterized by the absence of EP agents containing metal and phosphorus are used and as a result the exhaust gas aftertreatment device is protected from harmful exposure to such EP agents or their decomposition products. In accordance with the inventive method, the required oil change intervals are extended due to the fact that during operation of the engine, used engine oil is continuously or periodically removed from the engine and replaced with new oil. Unexpectedly, the levels of  $\text{NO}_x$  in exhaust gases from engines operating in accordance with the inventive method are reduced.

U.S. Patent 5,955,403 discloses a sulfur free lubricating oil composition which comprises a major portion of a synthetic base lubricating oil and a minor portion of a tri(alkyl phenyl) phosphate or di(alkylphenyl) phosphoric acid antiwear agent, an amine antioxidant a substituted succinamide rust inhibitor, and a tolyltriazole. The tri(alkylphenyl)phosphate antiwear agent is incorporated in the oil in an amount ranging between about 0.1 to 2.0 wt % and the amine antioxidant in amount ranging

from about 0.1 to 5 wt %. The succinamide is present in an amount ranging from about 0.01 to 0.5 wt %, and the tolyltriazole from about 0.01 to 0.5 wt %.

U.S. Patent 4,392,463 discloses a diesel engine having a first lubrication system, containing conventional engine oil, used to lubricate that section of the engine subjected to excessive wear—the valve train including the cam shaft, valve lifters, rocker arm, valve stems, etc., and a second lubricant system, utilizing diesel fuel, for lubricating the remaining section of the engine—the crankshaft and associated parts, pistons, connecting rods, etc. By being exposed to crankcase blowby exhaust gases, diesel fuel used to lubricate the crankshaft, etc. absorbs pollutants and contaminants contained therein and recirculates these contaminants through the fuel system to be burned and exhausted. By constantly being lubricated with fresh lubricant, wear on these specific parts is reduced. The reference indicates that frequent lubrication changes have been eliminated because the diesel fuel/lubricant is continuously changed and circulated through the fuel system. Since the engine oil and the first lubrication system is not exposed to crankcase blowby exhausted gases, its useful life is prolonged, thus reducing the frequency of required oil changes.

### **Summary of the Invention**

This invention relates to a low-sulfur consumable lubricating oil composition, comprising: a base oil; an acylated nitrogen-containing compound having a substituent of at least about 10 aliphatic carbon atoms; and a sulfur content of about 5 to about 250 ppm; said composition being characterized by the absence of an extreme-pressure additive containing metal and phosphorus.

This invention further relates to a a method of operating an internal combustion engine equipped with an exhaust gas aftertreatment device, said method comprising:

- (A) operating said engine using a normally liquid or gaseous fuel;

(B) lubricating said engine using the foregoing low-sulfur consumable lubricating oil composition;

(C) removing part of said low-sulfur consumable lubricating oil composition from said engine, said removed part of said low-sulfur consumable lubricating oil composition (i) being combined with said fuel and consumed with said fuel as said engine is operated or (ii) being combined with the exhaust gas from said engine and removed from said engine with said exhaust gas; and

(D) adding an additional amount of said low-sulfur consumable lubricating oil composition to said engine to replace said removed part of said low-sulfur consumable lubricating oil composition.

#### **Brief Description of the Drawings**

Fig. 1 is a schematic illustration of an internal combustion engine that is used in accordance with the inventive method, said engine being equipped with an exhaust gas aftertreatment device.

Fig. 2 is a plot of NO<sub>x</sub> levels in the exhaust gas generated in the engine test disclosed in Example 1 using a lubricating oil composition within the scope of the invention having a sulfur content of 11 ppm.

Fig. 3 is a plot of NO<sub>x</sub> levels in the exhaust gas generated in the engine test disclosed in Example 1 using a lubricating oil composition outside the scope of the invention having a sulfur content of 272 ppm. The engine test which resulted in the data plotted in Fig. 3 is disclosed for purposes of comparison.

#### **Description of the Preferred Embodiments**

The term "low-sulfur" when used to refer to the inventive consumable lubricating oil composition means that the lubricating oil composition has a sulfur content in the range of about 5 ppm to about 250 ppm.

The term "consumable" when used to refer to the inventive lubricating oil composition means that the oil composition may be either (i) mixed with and consumed with the fuel composition used in the inventive method, or (ii) mixed with the exhaust gas produced during the operation of the inventive method and removed from the engine with the exhaust gas as the inventive method is performed.

The term "exhaust gas aftertreatment device" is used herein to refer to any device used in the exhaust gas system of an internal combustion engine to reduce pollutants in the exhaust gas. These include catalytic converters, particulate traps, catalyzed traps, and the like.

The term "sulfur-free" when referring to additives or diluents for such additives used with the inventive low-sulfur consumable lubricating oil composition refers to a material that is free of elemental sulfur or contains an impurity level of elemental sulfur not exceeding about 25 ppm, and in one embodiment not exceeding about 15 ppm.

The term "hydrocarbyl" denotes a group having a carbon atom directly attached to the remainder of the molecule and having a hydrocarbon or predominantly hydrocarbon character within the context of this invention. Such groups include the following:

(1) Purely hydrocarbon groups; that is, aliphatic, (e.g., alkyl or alkenyl), alicyclic (e.g., cycloalkyl or cycloalkenyl), aromatic, aliphatic- and alicyclic-substituted aromatic, aromatic-substituted aliphatic and alicyclic groups, and the like, as well as cyclic groups wherein the ring is completed through another portion of the molecule (that is, any two indicated substituents may together form an alicyclic group). Such groups are known to those skilled in the art. Examples include methyl, ethyl, octyl, decyl, octadecyl, cyclohexyl, phenyl, etc.

(2) Substituted hydrocarbon groups; that is, groups containing non-hydrocarbon substituents which do not alter the predominantly hydrocarbon

character of the group. Those skilled in the art will be aware of suitable substituents. Examples include hydroxy, nitro, cyano, alkoxy, acyl, etc.

(3) Hetero groups; that is, groups which, while predominantly hydrocarbon in character, contain atoms other than carbon in a chain or ring otherwise composed of carbon atoms. Suitable hetero atoms will be apparent to those skilled in the art and include, for example, nitrogen or oxygen.

In general, no more than about three substituents or hetero atoms, and preferably no more than one, will be present for each 10 carbon atoms in the hydrocarbyl group.

Terms such as "alkyl-based," "aryl-based," and the like have meanings analogous to the above with respect to alkyl groups, aryl groups and the like.

The term "hydrocarbon-based" has the same meaning and can be used interchangeably with the term hydrocarbyl when referring to molecular groups having a carbon atom attached directly to the remainder of a molecule.

The term "lower" as used herein in conjunction with terms such as hydrocarbyl, alkyl, alkenyl, alkoxy, and the like, is intended to describe such groups which contain a total of up to 7 carbon atoms.

The term "oil-soluble" refers to a material that is soluble in mineral oil to the extent of at least about one gram per liter at 25°C.

#### **The Low-Sulfur Consumable Lubricating Oil Composition.**

The low-sulfur consumable lubricating oil composition, in one embodiment, may be comprised of components that add only C, H, O or N to the lubricating oil composition. In one embodiment, Si may be present. Excluding sulfur, as discussed below, any other elements that may be present are present as impurities and as such are at relatively low concentrations. The concentration of each of these impurities (prior to use of the oil in the engine) is typically less than about 500 ppm, and in one embodiment less than about 250 ppm, and in one embodiment less than about 100 ppm, and in one embodiment less than about 50 ppm, and in one

embodiment less than about 25 ppm, and in one embodiment less than about 10 ppm. This lubricating oil composition is characterized by the absence of EP additives comprised of metal (e.g., zinc) and phosphorus. In one embodiment, this lubricating oil composition is characterized by the absence of detergents or dispersants of the ash-producing type.

The sulfur in the inventive lubricating oil composition may be in any form. The sulfur may be elemental sulfur or it may present in the lubricating oil composition or added to the lubricating oil composition as part of a sulfur-containing compound. The sulfur-containing compound may be an inorganic sulfur compound or an organic sulfur compound. The sulfur-containing compound may be a compound containing one or more of the groups: sulfamoyl, sulfenamoyl, sulfeno, sulfido, sulfinamoyl, sulfino, sulfinyl, sulfo, sulfonio, sulfonyl, sulfonyldioxy, sulfate, thio, thiocarbamoyl, thiocarbonyl, thiocarbonylamino, thiocarboxy, thiocyanato, thioformyl, thioxo, thioketone, thioaldehyde, thioester, and the like. The sulfur may be present in a hetero group or compound which contains carbon atoms and sulfur atoms (and, optionally, other hetero atoms such as oxygen or nitrogen) in a chain or ring. The sulfur-containing compound may be a sulfur oxide such as sulfur dioxide or sulfur trioxide. The sulfur or sulfur-containing compound may be intentionally added to the inventive lubricating oil composition, or it may be present in the base oil or in one or more of the additives for the inventive lubricating oil composition as an impurity. The sulfur content in the inventive lubricating oil composition is critical and is in the range of about 5 to about 250 ppm, and in one embodiment about 5 to about 200 ppm, and in one embodiment about 5 to about 150 ppm, and in one embodiment about 5 to about 100 ppm, and in one embodiment about 5 to about 50 ppm, and in one embodiment about 5 to about 25 ppm, and in one embodiment about 5 to about 15 ppm, as measured by inductively coupled plasma (ICP) or x-ray techniques.



The low-sulfur consumable lubricating oil composition is comprised of one or more base oils which are generally present in a major amount (i.e. an amount greater than about 50% by weight). Generally, the base oil is present in an amount greater than about 60%, or greater than about 70%, or greater than about 80% by weight of the lubricating oil composition.

The low-sulfur consumable lubricating oil composition may have a viscosity of up to about 16.3 cSt at 100°C, and in one embodiment about 5 to about 16.3 cSt at 100°C, and in one embodiment about 6 to about 13 cSt at 100°C. In one embodiment, the lubricating oil composition has an SAE Viscosity Grade of 0W, 0W-20, 0W-30, 0W-40, 0W-50, 0W-60, 5W, 5W-20, 5W-30, 5W-40, 5W-50, 5W-60, 10W, 10W-20, 10W-30, 10W-40 OR 10W-50.

The low-sulfur consumable lubricating oil composition may have a high-temperature/high-shear viscosity at 150°C as measured by the procedure in ASTM D4683 of up to about 4 centipoise, and in one embodiment up to about 3.7 centipoise, and in one embodiment about 2 to about 4 centipoise, and in one embodiment about 2.2 to about 3.7 centipoise, and in one embodiment about 2.7 to about 3.5 centipoise.

The base oil used in the low-sulfur consumable lubricating oil composition may be a natural oil, synthetic oil or mixture thereof, provided the sulfur content of such oil does not exceed the above-indicated sulfur concentration limit required for the inventive low-sulfur lubricating oil composition. The natural oils that are useful include animal oils and vegetable oils (e.g., castor oil, lard oil) as well as mineral lubricating oils such as liquid petroleum oils and solvent treated or acid-treated mineral lubricating oils of the paraffinic, naphthenic or mixed paraffinic-naphthenic types. Oils derived from coal or shale are also useful. Synthetic lubricating oils include hydrocarbon oils such as polymerized and interpolymers of olefins (e.g., polybutylenes, polypropylenes, propylene isobutylene copolymers, etc.); poly(1-hexenes), poly(1-octenes), poly(1-decenes), etc. and mixtures thereof;

alkylbenzenes (e.g., dodecylbenzenes, tetradecylbenzenes, dinonylbenzenes, di-(2-ethylhexyl)benzenes, etc.); polyphenyls (e.g., biphenyls, terphenyls, alkylated polyphenyls, etc.); alkylated diphenyl ethers and the derivatives, analogs and homologs thereof and the like.

Alkylene oxide polymers and interpolymers and derivatives thereof where the terminal hydroxyl groups have been modified by esterification, etherification, etc., constitute another class of known synthetic lubricating oils that can be used. These are exemplified by the oils prepared through polymerization of ethylene oxide or propylene oxide, the alkyl and aryl ethers of these polyoxyalkylene polymers (e.g., methyl-polyisopropylene glycol ether having an average molecular weight of about 1000, diphenyl ether of polyethylene glycol having a molecular weight of about 500-1000, diethyl ether of polypropylene glycol having a molecular weight of about 1000-1500, etc.) or mono- and polycarboxylic esters thereof, for example, the acetic acid esters, mixed  $C_{3-8}$  fatty acid esters, or the  $C_{13}$  Oxo acid diester of tetraethylene glycol.

Another suitable class of synthetic lubricating oils that can be used comprises the esters of dicarboxylic acids (e.g., phthalic acid, succinic acid, alkyl succinic acids, alkenyl succinic acids, maleic acid, azelaic acid, suberic acid, sebacic acid, fumaric acid, adipic acid, linoleic acid dimer, malonic acid, alkyl malonic acids, alkenyl malonic acids, etc.) with a variety of alcohols (e.g., butyl alcohol, hexyl alcohol, dodecyl alcohol, 2-ethylhexyl alcohol, ethylene glycol, diethylene glycol monoether, propylene glycol, etc.) Specific examples of these esters include dibutyl adipate, di(2-ethylhexyl) sebacate, di-n-hexyl fumarate, dioctyl sebacate, diisooctyl azelate, diisodecyl azelate, dioctyl phthalate, didecyl phthalate, dieicosyl sebacate, the 2-ethylhexyl diester of linoleic acid dimer, the complex ester formed by reacting one mole of sebacic acid with two moles of tetraethylene glycol and two moles of 2-ethylhexanoic acid and the like.

Esters useful as synthetic oils also include those made from  $C_5$  to  $C_{12}$  monocarboxylic acids and polyols and polyol ethers such as neopentyl glycol, trimethylol propane, pentaerythritol, dipentaerythritol, tripentaerythritol, etc.

The oil can be a poly-alpha-olefin (PAO). Typically, the PAOs are derived from monomers having from about 4 to about 30, or from about 4 to about 20, or from about 6 to about 16 carbon atoms. Examples of useful PAOs include those derived from octene, decene, mixtures thereof, and the like. These PAOs may have a viscosity from about 2 to about 15, or from about 3 to about 12, or from about 4 to about 8 cSt at 100°C. Examples of useful PAOs include 4 cSt at 100°C poly-alpha-olefins, 6 cSt at 100°C poly-alpha-olefins, and mixtures thereof. Mixtures of mineral oil with one or more of the foregoing PAOs may be used.

Unrefined, refined and rerefined oils, either natural or synthetic (as well as mixtures of two or more of any of these) of the type disclosed hereinabove can be used in the lubricants of the present invention. Unrefined oils are those obtained directly from a natural or synthetic source without further purification treatment. For example, a shale oil obtained directly from retorting operations, a petroleum oil obtained directly from primary distillation or ester oil obtained directly from an esterification process and used without further treatment would be an unrefined oil. Refined oils are similar to the unrefined oils except they have been further treated in one or more purification steps to improve one or more properties. Many such purification techniques are known to those skilled in the art such as solvent extraction, secondary distillation, acid or base extraction, filtration, percolation, etc. Rerefined oils are obtained by processes similar to those used to obtain refined oils applied to refined oils which have been already used in service. Such rerefined oils are also known as reclaimed or reprocessed oils and often are additionally processed by techniques directed to removal of spent additives and oil breakdown products.

The acylated nitrogen-containing compound used in the inventive low-sulfur consumable lubricating oil composition typically functions as an ashless dispersant. A number of acylated nitrogen-containing compounds having a substituent of at least about 10 aliphatic carbon atoms and made by reacting a carboxylic acid acylating agent with an amino compound are known to those skilled in the art. In such compounds the acylating agent is linked to the amino compound through an imido, amido, amidine or salt linkage. The substituent of at least about 10 aliphatic carbon atoms may be in either the carboxylic acid acylating agent derived portion of the molecule or in the amino compound derived portion of the molecule. In one embodiment, it is in the acylating agent portion. The acylating agent can vary from formic acid and its acyl derivatives to acylating agents having high molecular weight aliphatic substituents of up to about 5,000, 10,000 or 20,000 carbon atoms. The amino compounds are characterized by the presence within their structure of at least one HN< group.

In one embodiment, the acylating agent is a mono- or polycarboxylic acid (or reactive equivalent thereof) such as a substituted succinic or propionic acid and the amino compound is a polyamine or mixture of polyamines, most typically, a mixture of ethylene polyamines. The amine also may be a hydroxyalkyl-substituted polyamine. The aliphatic substituent in such acylating agents typically averages at least about 30 or at least about 50 and up to about 400 carbon atoms.

Illustrative hydrocarbon based groups containing at least 10 carbon atoms are n-decyl, n-dodecyl, tetrapropylene, n-octadecyl, oleyl, chlorooctadecyl, triicontanyl, etc. Generally, the hydrocarbon-based substituents are made from homo- or interpolymers (e.g., copolymers, terpolymers) of mono- and di-olefins having 2 to 10 carbon atoms, such as ethylene, propylene, 1-butene, isobutene, butadiene, isoprene, 1-hexene, 1-octene, etc. Typically, these olefins are 1-monoolefins. The substituent can also be derived from the halogenated (e.g., chlorinated or brominated) analogs of such homo- or interpolymers. The substituent

can, however, be made from other sources, such as monomeric high molecular weight alkenes (e.g., 1-tetracontene) and chlorinated analogs and hydrochlorinated analogs thereof, aliphatic petroleum fractions, particularly paraffin waxes and cracked and chlorinated analogs and hydrochlorinated analogs thereof, white oils, synthetic alkenes such as those produced by the Ziegler-Natta process (e.g., poly(ethylene) greases) and other sources known to those skilled in the art. Any unsaturation in the substituent may be reduced or eliminated by hydrogenation according to procedures known in the art.

The hydrocarbon-based substituents are substantially saturated, that is, they contain no more than one carbon-to-carbon unsaturated bond for every ten carbon-to-carbon single bonds present. Usually, they contain no more than one carbon-to-carbon non-aromatic unsaturated bond for every 50 carbon-to-carbon bonds present.

The hydrocarbon-based substituents are also substantially aliphatic in nature, that is, they contain no more than one non-aliphatic moiety (cycloalkyl, cycloalkenyl or aromatic) group of 6 or less carbon atoms for every 10 carbon atoms in the substituent. Usually, however, the substituents contain no more than one such non-aliphatic group for every 50 carbon atoms, and in many cases, they contain no such non-aliphatic groups at all; that is, the typical substituents are purely aliphatic. Typically, these purely aliphatic substituents are alkyl or alkenyl groups.

Specific examples of the substantially saturated hydrocarbon-based substituents containing an average of more than about 30 carbon atoms are the following:

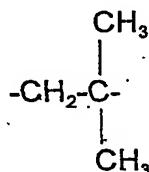
- a mixture of poly(ethylene/propylene) groups of about 35 to about 70 carbon atoms;

- a mixture of the oxidatively or mechanically degraded poly(ethylene/propylene) groups of about 35 to about 70 carbon atoms;

a mixture of poly(propylene/1-hexene) groups of about 80 to about 150 carbon atoms;

a mixture of poly(isobutene) groups having an average of about 50 to about 200 carbon atoms.

A useful source of the substituents are poly(isobutene)s obtained by polymerization of a C<sub>4</sub> refinery stream having a butene content of about 35 to about 75 weight percent and isobutene content of about 30 to about 60 weight percent in the presence of a Lewis acid catalyst such as aluminum trichloride or boron trifluoride. These polybutenes contain predominantly (greater than 80% of total repeating units) isobutene repeating units of the configuration



In one embodiment, the substituent is a polyisobutene group derived from a polyisobutene having a high methylvinylidene isomer content, that is, at least about 70% methylvinylidene, and in one embodiment at least about 80% methylvinylidene. Suitable high methylvinylidene polyisobutenes include those prepared using boron trifluoride catalysts. The preparation of such polyisobutenes in which the methylvinylidene isomer comprises a high percentage of the total olefin composition is described in U.S. Patents 4,152,499 and 4,605,808, the disclosures of each of which are incorporated herein by reference.

In one embodiment, the carboxylic acid acylating agent is a hydrocarbon substituted succinic acid or anhydride. The substituted succinic acid or anhydride consists of hydrocarbon-based substituent groups and succinic groups wherein the substituent groups are derived from a polyalkene, said acid or anhydride being

characterized by the presence within its structure of an average of at least about 0.9 succinic group for each equivalent weight of substituent groups, and in one embodiment about 0.9 to about 2.5 succinic groups for each equivalent weight of substituent groups. The polyalkene generally has a number average molecular weight ( $\bar{M}_n$ ) of at least about 700, and in one embodiment about 700 to about 2000, and in one embodiment about 900 to about 1800. The ratio between the weight average molecular weight ( $\bar{M}_w$ ) and the ( $\bar{M}_n$ ) (that is, the  $\bar{M}_w/\bar{M}_n$ ) can range from about 1 to about 10, or about 1.5 to about 5. In one embodiment the polyalkene has an  $\bar{M}_w/\bar{M}_n$  value of about 2.5 to about 5. For purposes of this invention, the number of equivalent weights of substituent groups is deemed to be the number corresponding to the quotient obtained by dividing the  $\bar{M}_n$  value of the polyalkene from which the substituent is derived into the total weight of the substituent groups present in the substituted succinic acid. Thus, if a substituted succinic acid is characterized by a total weight of substituent group of 40,000 and the  $\bar{M}_n$  value for the polyalkene from which the substituent groups are derived is 2000, then that substituted succinic acylating agent is characterized by a total of 20 ( $40,000/2000=20$ ) equivalent weights of substituent groups.

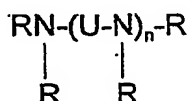
In one embodiment the carboxylic acid acylating agent is a substituted succinic acid or anhydride, said substituted succinic acid or anhydride consisting of hydrocarbon-based substituent groups and succinic groups wherein the substituent groups are derived from polybutene in which at least about 50% of the total units derived from butenes is derived from isobutylene. The polybutene is characterized by an  $\bar{M}_n$  value of about 1500 to about 2000 and an  $\bar{M}_w/\bar{M}_n$  value of about 3 to about 4. These acids or anhydrides are characterized by the presence within their structure of an average of about 1.5 to about 2.5 succinic groups for each equivalent weight of substituent groups.

In one embodiment the carboxylic acid is at least one substituted succinic acid or anhydride, said substituted succinic acid or anhydride consisting of

substituent groups and succinic groups wherein the substituent groups are derived from polybutene in which at least about 50% of the total units derived from butenes is derived from isobutylene. The polybutene has an  $\bar{M}_n$  value of about 800 to about 1200 and an  $\bar{M}_w/\bar{M}_n$  value of about 2 to about 3. The acids or anhydrides are characterized by the presence within their structure of an average of about 0.9 to about 1.2 succinic groups for each equivalent weight of substituent groups.

The amino compound is characterized by the presence within its structure of at least one  $\text{HN}<$  group and can be a monoamine or polyamine. Mixtures of two or more amino compounds can be used in the reaction with one or more acylating reagents. In one embodiment, the amino compound contains at least one primary amino group (i.e.,  $-\text{NH}_2$ ) and more preferably the amine is a polyamine, especially a polyamine containing at least two  $-\text{NH}-$  groups, either or both of which are primary or secondary amines. The amines may be aliphatic, cycloaliphatic, aromatic or heterocyclic amines.

Among the useful amines are the alkylene polyamines, including the polyalkylene polyamines. The alkylene polyamines include those conforming to the formula



wherein  $n$  is from 1 to about 10; each  $\text{R}$  is independently a hydrogen atom, a hydrocarbyl group or a hydroxy-substituted or amine-substituted hydrocarbyl group having up to about 30 atoms, or two  $\text{R}$  groups on different nitrogen atoms can be joined together to form a  $\text{U}$  group, with the proviso that at least one  $\text{R}$  group is a hydrogen atom and  $\text{U}$  is an alkylene group of about 2 to about 10 carbon atoms.  $\text{U}$  may be ethylene or propylene. Alkylene polyamines where each  $\text{R}$  is hydrogen or an amino-substituted hydrocarbyl group with the ethylene polyamines and mixtures of ethylene polyamines are useful. Usually  $n$  will have an average value



of from about 2 to about 7. Such alkylene polyamines include methylene polyamine, ethylene polyamines, propylene polyamines, butylene polyamines, pentylene polyamines, hexylene polyamines, heptylene polyamines, etc. The higher homologs of such amines and related amino alkyl-substituted piperazines are also included.

Alkylene polyamines that are useful include ethylene diamine, triethylene tetramine, propylene diamine, trimethylene diamine, hexamethylene diamine, decamethylene diamine, octamethylene diamine, di(heptamethylene) triamine, tripropylene tetramine, tetraethylene pentamine, trimethylene diamine, pentaethylene hexamine, di(trimethylene)triamine, N-(2-aminoethyl)piperazine, 1,4-bis(2-aminoethyl)piperazine, and the like. Higher homologs as are obtained by condensing two or more of the above-illustrated alkylene amines are useful, as are mixtures of two or more of any of the afore-described polyamines.

Ethylene polyamines, such as those mentioned above, are especially useful for reasons of cost and effectiveness. Such polyamines are described in detail under the heading "Diamines and Higher Amines" in The Encyclopedia of Chemical Technology, Second Edition, Kirk and Othmer, Volume 7, pages 27-39, Interscience Publishers, Division of John Wiley and Sons, 1965, which is hereby incorporated by reference for the disclosure of useful polyamines. Such compounds are prepared most conveniently by the reaction of an alkylene chloride with ammonia or by reaction of an ethylene imine with a ring-opening reagent such as ammonia, etc. These reactions result in the production of the somewhat complex mixtures of alkylene polyamines, including cyclic condensation products such as piperazines.

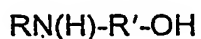
Other useful types of polyamine mixtures are those resulting from stripping of the above-described polyamine mixtures. In this instance, lower molecular weight polyamines and volatile contaminants are removed from an alkylene polyamine mixture to leave as residue what is often termed "polyamine bottoms". In general, alkylene polyamine bottoms can be characterized as having less than about 2% by weight, usually less than about 1% by weight material boiling below about 200°C.

In the instance of ethylene polyamine bottoms, which are readily available and found to be quite useful, the bottoms contain less than about 2% by weight total diethylene triamine (DETA) or triethylene tetramine (TETA). A typical sample of such ethylene polyamine bottoms obtained from the Dow Chemical Company of Freeport, Texas designated "E-100" showed a specific gravity at 15.6°C of 1.0168, a percent nitrogen by weight of 33.15 and a viscosity at 40°C of 121 centistokes. Gas chromatography analysis of such a sample indicates it contains about 0.93% "Light Ends" (most probably DETA), 0.72% TETA, 21.74% tetraethylene pentamine and 76.61% pentaethylene hexamine and higher (by weight). These alkylene polyamine bottoms include cyclic condensation products such as piperazine and higher analogs of diethylenetriamine, triethylenetetramine and the like.

These alkylene polyamine bottoms can be reacted solely with the acylating agent, in which case the amino reactant consists essentially of alkylene polyamine bottoms, or they can be used with other amines and polyamines, or alcohols or mixtures thereof. In these latter cases at least one amino reactant comprises alkylene polyamine bottoms.

Other polyamines are described in, for example, U.S. Patents 3,219,666 and 4,234,435, and these patents are hereby incorporated by reference for their disclosures of amines which can be reacted with the acylating agents described above to form useful acylated nitrogen-containing compounds.

In one embodiment, the amine may be a hydroxyamine. Typically, the hydroxyamines are primary, secondary or tertiary alkanol amines or mixtures thereof. Such amines can be represented by the formulae:

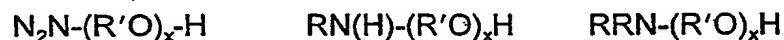


wherein each R is independently a hydrocarbyl group of one to about eight carbon atoms or hydroxyhydrocarbyl group of two to about eight carbon atoms, preferably

one to about four, and R' is a divalent hydrocarbyl group of about two to about 18 carbon atoms, preferably two to about four. The group -R'-OH in such formulae represents the hydroxyhydrocarbyl group. R' can be an acyclic, alicyclic or aromatic group. Typically, R' is an acyclic straight or branched alkylene group such as an ethylene, 1,2-propylene, 1,2-butylene, 1,2-octadecylene, etc. group. Where two R groups are present in the same molecule they can be joined by a direct carbon-to-carbon bond or through a heteroatom (e.g., oxygen or nitrogen) to form a 5-, 6-, 7- or 8-membered ring structure. Examples of such heterocyclic amines include N-(hydroxyl lower alkyl)-morpholines, -piperidines, -oxazolidines, and the like. Typically, however, each R' is independently a methyl, ethyl, propyl, butyl, pentyl or hexyl group.

Examples of these alkanolamines include mono-, di-, and triethanol amine, diethylethanolamine, ethylethanolamine, butyldiethanolamine, etc.

The hydroxyamines can also be an ether N-(hydroxyhydrocarbyl)-amine. These are hydroxypoly(hydrocarbyloxy) analogs of the above-described hydroxy amines (these analogs also include hydroxyl-substituted oxyalkylene analogs). Such N-(hydroxyhydrocarbyl) amines can be conveniently prepared by reaction of epoxides with afore-described amines and can be represented by the formulae:



wherein x is a number from about 2 to about 15 and R and R' are as described above. R may also be a hydroxypoly(hydrocarbyloxy) group.

The acylated nitrogen-containing compounds include amine salts, amides, imides, amidines, amidic acids, amidic salts and imidazolines as well as mixtures thereof. To prepare the acylated nitrogen-containing compounds from the acylating reagents and the amino compounds, one or more acylating reagents and one or more amino compounds are heated, optionally in the presence of a normally liquid,

substantially inert organic liquid solvent/diluent, at temperatures in the range of about 80°C up to the decomposition point of either the reactants or the carboxylic derivative but normally at temperatures in the range of about 100°C up to about 300°C provided 300°C does not exceed the decomposition point. Temperatures of about 125°C to about 250°C are normally used. The acylating reagent and the amino compound are reacted in amounts sufficient to provide from about one-half equivalent up to about 2 moles of amino compound per equivalent of acylating reagent.

Many patents have described useful acylated nitrogen-containing compounds including U.S. Patents 3,172,892; 3,219,666; 3,272,746; 3,310,492; 3,341,542; 3,444,170; 3,455,831; 3,455,832; 3,576,743; 3,630,904; 3,632,511; 3,804,763; and 4,234,435. A typical acylated nitrogen-containing compound of this class is that made by reacting a poly(isobutene)-substituted succinic acid acylating agent (e.g., anhydride, acid, ester, etc.) wherein the poly(isobutene) substituent has between about 50 to about 400 carbon atoms with a mixture of ethylenepolyamines having about 3 to about 7 amino nitrogen atoms per ethylenepolyamine and about 1 to about 6 ethylene units. The above-noted U.S. patents are hereby incorporated by reference for their disclosure of acylated amino compounds and their method of preparation.

Another type of acylated nitrogen-containing compound belonging to this class is that made by reacting a carboxylic acid acylating agent with a polyamine, wherein the polyamine is the product made by condensing a hydroxy material with an amine. These compounds are described in U.S. Patent 5,053,152 which is incorporated herein by reference for its disclosure of such compounds.

Another type of acylated nitrogen-containing compound belonging to this class is that made by reacting the afore-described alkyleneamines with the afore-described substituted succinic acids or anhydrides and aliphatic monocarboxylic acids having from 2 to about 22 carbon atoms. In these types of

acylated nitrogen compounds, the mole ratio of succinic acid to monocarboxylic acid ranges from about 1:0.1 to about 1:1. Typical of the monocarboxylic acid are formic acid, acetic acid, dodecanoic acid, butanoic acid, oleic acid, stearic acid, the commercial mixture of stearic acid isomers known as isostearic acid, tall oil acid, etc. Such materials are more fully described in U.S. Patents 3,216,936 and 3,250,715 which are hereby incorporated by reference for their disclosures in this regard.

Still another type of acylated nitrogen-containing compound that may be useful is the product of the reaction of a fatty monocarboxylic acid of about 12-30 carbon atoms and the afore-described alkyleneamines, typically, ethylene-, propylene- or trimethylenepolyamines containing 2 to 8 amino groups and mixtures thereof. The fatty monocarboxylic acids are generally mixtures of straight and branched chain fatty carboxylic acids containing 12-30 carbon atoms. A widely used type of acylated nitrogen compound is made by reacting the afore-described alkyleneamines with a mixture of fatty acids having from 5 to about 30 mole percent straight chain acid and about 70 to about 95% mole branched chain fatty acids. Among the commercially available mixtures are those known widely in the trade as isostearic acid. These mixtures are produced as a by-product from the dimerization of unsaturated fatty acids as described in U.S. Patents 2,812,342 and 3,260,671.

The branched chain fatty acids can also include those in which the branch is not alkyl in nature, such as found in phenyl and cyclohexyl stearic acid and the chloro-stearic acids. Branched chain fatty carboxylic acid/alkylene polyamine products have been described extensively in the art. See for example, U.S. Patents 3,110,673; 3,251,853; 3,326,801; 3,337,459; 3,405,064; 3,429,674; 3,468,639; 3,857,791. These patents are hereby incorporated by reference for their disclosure of fatty acid/polyamine condensates for use in lubricating oil formulations.

In one embodiment, the inventive low-sulfur consumable lubricating oil composition is characterized by a chlorine level of no more than about 10 ppm, and in one embodiment no more than about 7 ppm, and in one embodiment no more than about 5 ppm. This necessitates that the acylated nitrogen-containing compound be chlorine-free or contain such low chlorine levels that the addition of such compound to the lubricating oil composition results in the formation of a lubricating oil composition with a chlorine level of no more than about 10 ppm. In one embodiment, the acylated nitrogen-containing compound has a chlorine content of no more than about 50 ppm, and in one embodiment no more than about 25 ppm, and in one embodiment no more than about 10 ppm. In one embodiment, the acylated nitrogen-containing compound is chlorine free.

The acylated nitrogen-containing compound is typically employed in the low-sulfur consumable lubricating oil composition at a concentration in the range of about 1% to about 25% percent by weight, and in one embodiment about 5% to about 15% by weight. These compounds can be added directly to the lubricating oil composition. In one embodiment, however, they are diluted with a substantially inert, normally liquid organic diluent such as mineral oil, naphtha, benzene, toluene or xylene to form an additive concentrate. These concentrates usually contain from about 1% to about 99% by weight, and in one embodiment about 10% to about 90% by weight of the diluent. In one embodiment, the organic diluent is a sulfur-free composition.

An advantage of the inventive low-sulfur consumable lubricating oil compositions is that these oil compositions may be easier to dispose of from an environmental perspective than conventional lubricating oils. This is due to the absence of EP additives containing phosphorus and metal in these lubricating oil compositions. Conventional lubricating oil compositions, on the other hand, typically contain relatively high concentrations of such EP additives.

The low-sulfur consumable lubricating oil composition may contain, in addition to the base oil, sulfur and acylated nitrogen-containing compounds referred to above, one or more detergents or dispersants of the ashless type. The ashless detergents and dispersants are so called despite the fact that, depending on their constitution, they may upon combustion yield a non-volatile material such as boric oxide; however, they do not ordinarily contain metal and therefore do not yield a metal-containing ash on combustion. Many types are known in the art, and are suitable for use in these lubricating oil compositions. These include the following:

(1) Reaction products of carboxylic acids (or derivatives thereof) containing at least about 34, and in one embodiment at least about 54 carbon atoms, with organic hydroxy compounds such as phenols and alcohols, and/or basic inorganic materials. Examples of these "carboxylic dispersants" are described in many U.S. Patents including 3,219,666; 4,234,435; and 4,938,881.

(2) Reaction products of relatively high molecular weight aliphatic or alicyclic halides with amines, preferably oxyalkylene polyamines. These may be characterized as "amine dispersants" and examples thereof are described for example, in the following U.S. Patents: 3,275,554; 3,438,757; 3,454,555; and 3,565,804.

(3) Reaction products of alkyl phenols in which the alkyl group contains at least about 30 carbon atoms with aldehydes (especially formaldehyde) and amines (especially polyalkylene polyamines), which may be characterized as "Mannich dispersants." The materials described in the following U.S. Patents are illustrative: 3,649,229; 3,697,574; 3,725,277; 3,725,480; 3,726,882; and 3,980,569.

(4) Products obtained by post-treating the amine or Mannich dispersants with such reagents as urea, aldehydes, ketones, carboxylic acids, hydrocarbon-substituted succinic anhydrides, nitriles, epoxides, boron compounds, phosphorus compounds or the like. Exemplary materials of this kind are described

in the following U.S. Patents: 3,639,242; 3,649,229; 3,649,659; 3,658,836; 3,697,574; 3,702,757; 3,703,536; 3,704,308; and 3,708,422.

(5) Interpolymers of oil-solubilizing monomers such as decyl methacrylate, vinyl decyl ether and high molecular weight olefins with monomers containing polar substituents, e.g., aminoalkyl acrylates or acrylamides and poly-(oxyethylene)-substituted acrylates. These may be characterized as "polymeric dispersants" and examples thereof are disclosed in the following U.S. Patents: 3,329,658; 3,449,250; 3,519,565; 3,666,730; 3,687,849; and 3,702,300.

The above-noted patents are incorporated by reference herein for their disclosures of ashless dispersants.

The low-sulfur consumable lubricating oil composition may also contain other lubricant additives known in the art. These include, for example, corrosion-inhibiting agents, antioxidants, viscosity modifiers, pour point depressants, friction modifiers, fluidity modifiers, anti-foam agents, etc.

Pour point depressants are used to improve the low temperature properties of oil-based compositions. See, for example, page 8 of "Lubricant Additives" by C.V. Smalheer and R. Kennedy Smith (Lezius Hiles Co. publishers, Cleveland, Ohio, 1967). Examples of useful pour point depressants are polymethacrylates; polyacrylates; polyacrylamides; condensation products of haloparaffin waxes and aromatic compounds; vinyl carboxylate polymers; and terpolymers of dialkylfumarates, vinyl esters of fatty acids and alkyl vinyl ethers. Pour point depressants are described in U.S. Patents 2,387,501; 2,015,748; 2,655,479; 1,815,022; 2,191,498; 2,666,746; 2,721,877; 2,721,878; and 3,250,715 which are herein incorporated by reference for their relevant disclosures.

Anti-foam agents are used to reduce or prevent the formation of stable foam. Typical anti-foam agents include silicones or organic polymers. Additional antifoam compositions are described in "Foam Control Agents," by Henry T. Kerner (Noyes Data Corporation, 1976), pages 125-162.



Each of the foregoing additives, when used, is used at a functionally effective amount to impart the desired properties to the lubricant. Thus, for example, if an additive is a corrosion inhibitor, a functionally effective amount of this corrosion inhibitor would be an amount sufficient to impart the desired corrosion inhibition characteristics to the lubricant. Generally, the concentration of each of these additives, when used, ranges from about 0.001% to about 20% by weight, and in one embodiment about 0.01% to about 10% by weight based on the total weight of the low-sulfur consumable lubricating oil composition.

These additives can be added directly to the low-sulfur consumable lubricating oil composition. In one embodiment, however, they are diluted with a substantially inert, normally liquid organic diluent such as mineral oil, naphtha, benzene, toluene or xylene to form an additive concentrate. These concentrates usually contain from about 1% to about 99% by weight, and in one embodiment about 10% to about 90% by weight of such diluent. In one embodiment, this diluent is a sulfur-free composition.

#### **Method of Operating Internal Combustion Engine.**

The inventive method will be initially discussed with reference to Fig. 1. The engine 10 may be a spark ignition internal combustion engine, which may be referred to as a gasoline powered engine, or compression ignition internal combustion engine, which may be referred to as a diesel engine. The spark ignition engine may be a four-stroke internal combustion engine.

The engine 10 may employ a split lubrication system where the high-wear areas or components of the engine are lubricated using a conventional lubricating oil composition, and the crankcase is lubricated using the inventive low-sulfur consumable lubricating oil composition. The high-wear areas lubricated using a conventional lubricating oil composition include the valve train (including the cam shaft and associated parts such as cam lobes, tappets, followers, valve tips, rocker arms, rocker arm mechanisms, and the like). The crankcase lubricated using the

inventive low-sulfur consumable lubricating oil composition may include the crankshaft and associated parts, pistons, connecting rods, and the like. Engines employing split lubrication systems of this type are disclosed in U.S. Patents 4,392,463; 5,195,474; and 5,709,186; and French Patent 2,605,677. These patents are incorporated herein by reference for their disclosure of engines employing split lubrication systems.

The engine 10 may be lubricated in the high-wear areas using a solid film lubricant and in the remaining areas using the inventive low-sulfur consumable lubricating oil composition. The high-wear areas may be lubricated using a combination of a solid film lubricant and the inventive low-sulfur consumable lubricating oil composition. The solid film lubricant may be any solid film lubricant that provides enhanced wear resistance characteristics and enhanced lubricity characteristics when applied to wear interfaces or contacts as compared to when the solid film lubricant is not present. The solid film lubricant may have a film thickness of about 5 to about 100 microns, and in one embodiment about 5 to about 75 microns. The solid film lubricant may be applied to the desired engine components by the engine manufacturer. Among the high wear areas or components of the engines that may be so lubricated are wear interfaces or contacts in the valve train. These include the wear interfaces or contacts of the cam lobes, tappets, followers, valve tips, rocker arms, rocker arm mechanisms, and the like. Additional engine components that may be lubricated in this manner include the wear interfaces or contacts of the cylinder bores, cylinder walls, piston rings, skirts, bearings, connecting rods, and the like. Included among the solid film lubricants that may be used are those disclosed in U.S. Patent 5,482,637 which discloses solid film lubricants comprised of at least two solid lubricants selected from graphite,  $\text{MoS}_2$ , and BN. U.S. Patent 5,358,753 discloses solid film lubricants comprised of graphite and  $\text{MoS}_2$ . International Publication WO 97/13884 discloses a composite coating of a metal and an oxide of the metal wherein the oxide has a

lower oxygen content than any of the metal's oxide forms, the metal being selected from Ni, Cu, Mo, Fe or an alloy thereof. German Patent DE 195 48 718 C1 discloses solid film lubricants comprised of a metal oxide coating wherein the metal is Ti, Al, Mo, V or Cr. The solid film lubricant may be a carbon coating that is applied under vacuum by a laser. The foregoing patents are incorporated herein by reference for their disclosures of solid film lubricants.

The engine 10 may be a camless internal combustion engine. Camless internal combustion engines do not employ a camshaft for controlling the timing and lifting of the engine's intake and exhaust valves. These engines typically employ intake valves and exhaust valves that are electrically actuated, hydraulically actuated or electrohydraulically actuated. Examples of such engines are disclosed in U.S. Patents 5,255,641; 5,311,711; 5,367,990; 5,373,817; 5,377,631; 5,404,844; 5,419,301; 5,456,221; 5,456,222; 5,562,070; 5,572,961; 5,615,646; 5,619,965; 5,694,893; 5,709,178; 5,758,625; 5,970,956; and 6,024,060, which are incorporated by reference for their disclosures of camless engines.

The engine 10 includes a crankcase 12, and a fuel system 14, which includes a fuel tank, fuel pump, fuel injectors, fuel filter, and the like. The fuel mixes with air, and undergoes combustion in the combustion chambers of the engine. An exhaust gas is removed from the engine as indicated by arrow 16. An exhaust gas aftertreatment device 18 (e.g., catalytic converter, particulate trap, catalyzed trap, and the like) and an exhaust muffler 20 are provided as part of an exhaust system for removing exhaust gas from the engine. The engine 10 includes a pump (not shown) for circulating oil throughout the engine and an oil sump 22. The engine 10 is equipped with a make-up oil reservoir 24 and a pump or metering device 26 for advancing new oil from the make-up oil reservoir 24 to the crankcase 12.

The engine 10 operates in the normal sequence with the fuel being advanced from the fuel system 14 to the combustion chambers of the engine where a mixture of the fuel and air undergoes combustion. The exhaust gas from the engine is

removed through the exhaust gas aftertreatment device 18 and exhaust muffler 20. During the operation of this engine, the low-sulfur consumable lubricating oil composition circulates through the engine in the normal manner lubricating the desired engine components. A portion of the low-sulfur consumable lubricating oil composition used in the engine collects in oil sump 22, and is pumped from oil sump 22 to fuel system 14, as indicated by directional arrow 28, where it is combined with the fuel. The introduction of the oil into the fuel may occur in one or more of the fuel tank, fuel return line, fuel injectors, intake manifold, positive crankcase ventilation (PCV) system, exhaust gas recirculation (EGR) system, intake and/or exhaust valve guides, or air intake system of the engine 10.

The resulting combination of fuel and oil is comprised of about 0.01% to about 5% by weight of said oil, and in one embodiment about 0.05% to about 3% by weight, and in one embodiment about 0.1% to about 1.5% by weight, and in one embodiment about 0.1% to about 1% by weight, and in one embodiment about 0.1% to about 0.7% by weight, and in one embodiment about 0.1% to about 0.5% by weight, and in one embodiment about 0.2% to about 0.3% by weight of said oil, with the remainder being fuel.

Alternatively (as shown in the dashed line 30 in Fig. 1), the portion of the low-sulfur consumable lubricating oil composition removed from the oil sump 22 may be advanced to the exhaust gas system where it is combined with the exhaust gas at any point in the exhaust gas system upstream of (i.e., prior to entry into) the exhaust gas aftertreatment device 18.

The sequence of removing used oil from the engine and replacing it with new oil may be performed continuously or intermittently during the operation of the engine.

The fuel may be a normally liquid or gaseous fuel. These include hydrocarbonaceous petroleum distillate fuels such as motor gasoline as defined by ASTM Specification D439 and diesel fuel as defined by ASTM Specification D396.

Normally liquid hydrocarbon fuels containing materials such as alcohols, ethers, organo-nitro compounds and the like (e.g., methanol, ethanol, diethyl ether, methyl ethyl ether, nitromethane) are also within the scope of this invention as are liquid fuels derived from vegetable or mineral sources such as corn, alfalfa, shale and coal. Examples of such mixtures include gasoline and ethanol, and diesel fuel and ether.

In one embodiment, the fuel is gasoline, that is, a mixture of hydrocarbons having an ASTM distillation range from about 60°C. at the 10% distillation point to about 205°C. at the 90% distillation point. In one embodiment, the gasoline fuel composition is an unleaded fuel composition. In one embodiment, the gasoline is a chlorine-free or low-chlorine gasoline characterized by a chlorine content of no more than about 10 ppm. In one embodiment, the gasoline is a low-sulfur fuel characterized by a sulfur content of no more than about 300 ppm, and in one embodiment no more than about 150 ppm, and in one embodiment no more than about 100 ppm, and in one embodiment no more than about 50 ppm, and in one embodiment no more than about 25 ppm, and in one embodiment no more than about 10 ppm.

The diesel fuel that is useful may be any diesel fuel. These diesel fuels typically have a 90% point distillation temperature in the range of about 300°C to about 390°C, and in one embodiment about 330°C to about 350°C. The viscosity for these fuels typically ranges from about 1.3 to about 24 centistokes at 40°C. The diesel fuels can be classified as any of Grade Nos. 1-D, 2-D or 4-D as specified in ASTM D975. These diesel fuels may contain alcohols and esters. In one embodiment the diesel fuel has a sulfur content of up to about 0.05% by weight (low-sulfur diesel fuel) as determined by the test method specified in ASTM D2622-87.

The fuel compositions may contain one or more fuel additives known in the art for enhancing the performance of the fuel. These include deposit preventers or

modifiers, dyes, cetane improvers, antioxidants such as 2,6-di-tertiary-butyl-4-methyl-phenol, corrosion inhibitors such as alkylated succinic acids and anhydrides, bacteriostatic agents, gum inhibitors, metal deactivators, demulsifiers, upper cylinder lubricants, anti-icing agents, ashless dispersants, and the like.

The fuel additives may be added directly to the fuel, or they may be diluted with a normally liquid organic diluent such as naphtha, benzene, toluene, or xylene to form an additive concentrate prior to addition to the fuel. These concentrates typically contain from about 10% to about 90% by weight diluent.

The fuel may be a gaseous fuel such as natural gas. The fuel may be stored as a liquid and used in its gaseous form. Examples include propane and dimethyl ether.

#### Example 1

Engine tests are conducted using a 2.3 liter, overhead cam, four-cylinder Ford electronic fuel injected engine. The engine is operated at low- and mid-range speeds and temperatures for 288 hours, simulating stop-and-go urban and moderate freeway driving. The test conditions involve 72 cycles, each being 4 hours in length and having 3 stages, for a total test time of 288 hours. The length of time and operating conditions for each stage is as follows:

<u>Stage</u>	<u>Hours</u>	<u>Speed (ppm)</u>	<u>Load (kW)</u>	<u>Oil (°C)</u>	<u>Coolant (°C)</u>
1	2.00	2500	25.0	68.3	51.7
2	1.25	2500	25.0	98.9	85.0
3	0.75	750	0.7	46.1	46.1

The valve train (i.e., cam shaft, valve lifters, rocker arms, valve stems, etc.) is separated from the crankcase (i.e., crankshaft, pistons, connecting rods, etc.) to simulate a split engine design. The standard Cu-Pb bearings are replaced with Al-Sn bearings. A Johnson Matthey JM220K catalyst is installed in the exhaust system.

The fuel is an unleaded gasoline fuel composition having a sulfur content of 28 ppm. The valve train is lubricated using a conventional lubricating oil composition. The crankcase is lubricated using the following ashless lubricating oil compositions (in the table below all numerical values provided for the components of the composition (except the foam inhibitor) are in percent by weight).

## 3.1

	<u>A</u>	<u>B</u>
Base oil - - SAE 5W-30 Polyalpha olefin oil mixture (80% by wt. polyalphaolefin having viscosity of 6 cSt @ 100°C and 20% by wt. polyalphaolefin having viscosity of 4 cSt 100°C)	83.4	83.4
Dispersant - - Succinimide derived from high vinylidene polyisobutene (number average molecular weight (Mn) equal to about 1000) substituted succinic anhydride and tetraethylene pentamine (Nitrogen content = 3.3% by wt.) dispersed in oil (40% by wt. sulfur-free 100N (neutral) mineral oil)	14.3	--
Dispersant - - Succinimide derived from high vinylidene polyisobutene (Mn equal to about 1000) substituted succinic anhydride and tetraethylene pentamine (Nitrogen content = 3.3% by wt.) dispersed in oil (40% by wt. 100N mineral oil)	--	14.3
Viscosity modifier - - LZ 7067 (a product of Lubrizol identified as an olefin copolymer)	0.8	0.8
Diluent oil (sulfur-free 100N mineral oil)	0.38	--
Diluent oil (100N mineral oil)	--	0.38
Corrosion inhibitor - - Pluradyne FL11 (product of BASF identified as an ethylene oxide-propylene oxide copolymer)	0.02	0.02
Antioxidant - - Nonylated diphenylamine	0.6	0.6
Antioxidant - - 4,4'-methylene bis 2,6-di-t-butyl phenol	0.5	0.5
Foam inhibitor - - Polydimethyl siloxane dispersed in kerosene (90% kerosene)	50ppm	50ppm
Physical properties:		
Viscosity @ 100°C, cSt	11.43	11.59
Viscosity @ 40°C, cSt	68.20	70.71
Viscosity index	162	159
High Temperature/High Shear @ 150°C, cP (ASTM D 4683)	3.50	3.46
Chemical properties:		
% P, Zn, Si, Ca, Mg, Na, Halogen	nil	nil
% N, wt%	0.492	0.492
Si, ppm	2	2
S, ppm	11	272



The crankcase of the engine is lubricated using lubricating oil composition A. A first peristaltic pump continuously removes used lubricating oil composition A from the crankcase of the engine at a rate of 0.55 liter per 24 hours (0.0229 liter per hour) and advances the used oil to the fuel tank where it is mixed with the gasoline in the fuel tank. A second peristaltic pump continuously adds fresh lubricating oil composition A to the crankcase of the engine at a rate of 0.55 liter per 24 hours to replace the used oil that is removed. The fuel usage per 24 hour interval is 110 liters, the oil usage per 24 hour interval being 0.55 liter. The content of the oil in the fuel is 0.5% by weight. The  $\text{NO}_x$  level in the exhaust gas is measured before entering the catalyst and after passing through the catalyst with the results being plotted in Fig. 2.

In a comparative test run, the crankcase of the engine is lubricated using the lubricating composition B. The gasoline fuel composition contains 0.5% by weight of a freshly blended sample of lubricating oil composition B. The fuel usage per 24 hour interval is 110 liters, the oil usage per 24 hour interval being 0.55 liter. At 24 hour intervals, 0.71 liter samples of crankcase oil are removed, and replaced with 0.55 liter of new oil plus 0.16 liter of the removed oil. The  $\text{NO}_x$  level in the exhaust gas is measured before entering the catalyst and after passing through the catalyst with the results being plotted in Fig. 3. This test is provided for purposes of comparison.

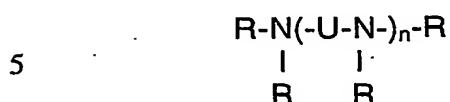
The foregoing illustrates an advantage of the inventive method which is to provide a low level of  $\text{NO}_x$  in the exhaust gas of an internal combustion engine equipped with an exhaust gas aftertreatment device.

While the invention has been explained in relation to its preferred embodiments, it is to be understood that various modifications thereof will become apparent to those skilled in the art upon reading the specification. Therefore, it is to be understood that the invention disclosed herein is intended to cover such modifications as fall within the scope of the appended claims.

Claims

1. A low-sulfur consumable lubricating oil composition, comprising:  
5 a base oil;  
an acylated nitrogen-containing compound having a substituent  
of at least 10 aliphatic carbon atoms; and  
a sulfur content of 5 to 250 ppm;  
said composition being characterized by the absence of an  
10 extreme-pressure additive comprised of metal and phosphorus.
2. The composition of claim 1 wherein said lubricating oil composition is comprised of components that add only C, H, O or N, and optionally Si to said composition.
3. The composition of claim 1 wherein said low-sulfur consumable  
15 lubricating oil composition has a viscosity of up to 16.3 cSt at 100°C.
4. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition has an SAE Viscosity Grade of 0W, 0W-20, 0W-30, 0W-40, 0W-50, 0W-60, 5W, 5W-20, 5W-30, 5W-40, 5W-50, 5W-60, 10W, 10W-20, 10W30, 10W-40 or 10W-50.
- 20 5. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition has a high-temperature/high-shear viscosity at 150°C of up to  $4 \times 10^{-3}$  Pa·s (4 centipoise).
6. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition is comprised of a mineral base oil.
- 25 7. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition is comprised of a poly-alpha-olefin base oil.
8. The composition of claim 1 wherein said acylated nitrogen-containing compound is derived from a carboxylic acylating agent and at least one amino compound containing at least one -NH- group,  
30 said acylating agent being linked to said amino compound through an imido, amido, amidine or salt linkage.

im 8 whe  
alkylenepolyamine represented by the formula:



wherein U is an alkylene group of from 2 to 10 carbon atoms; each R is independently a hydrogen atom, a hydrocarbyl group, a hydroxy-substituted hydrocarbyl group, or an amine-substituted hydrocarbyl group containing up to 30 carbon atoms, with the proviso that at least one R is a hydrogen atom; and n is 1 to 10.

10. The composition of claim 8 wherein said carboxylic acylating agent is a mono- or polycarboxylic acid or anhydride containing an aliphatic hydrocarbyl substituent of at least 30 carbon atoms.

11. The composition of claim 1 wherein said acylated nitrogen-containing compound is a polyisobutene substituted succinimide containing at least 50 aliphatic carbon atoms in the polyisobutene group.

12. The composition of claim 1 wherein said acylated-nitrogen-containing compound has a chlorine content of no more than 50 ppm.

13. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition is a low-ash lubricating oil composition which further comprises an ash-producing detergent or dispersant.

14. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition is characterized by the absence of an ash-producing detergent or dispersant.

15. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition is comprised of at least one ashless detergent or dispersant, corrosion-inhibiting agent, antioxidant, viscosity modifier, pour point depressant, friction modifier, fluidity modifier, or anti-foam agent.

16. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition has a sulfur content of 5 to 50 ppm.

17. The composition of claim 1 wherein said low-sulfur consumable lubricating oil composition has a chlorine content of no more than 10 ppm.

18. A method of operating an internal combustion engine  
5 equipped with an exhaust gas aftertreatment device, said method comprising:

(A) operating said engine using a normally liquid or gaseous fuel;

(B) lubricating said engine using a low-sulfur consumable  
10 lubricating oil composition, said oil composition comprising: a base oil; an acylated nitrogen-containing compound having a substituent of at least 10 aliphatic carbon atoms; and a sulfur content of 5 to 250 ppm; said oil composition being characterized by the absence of an extreme-pressure additive comprised of metal and phosphorus;

(C) removing part of said low-sulfur consumable lubricating  
15 oil composition from said engine, said removed part of said low-sulfur consumable lubricating oil composition (i) being combined with said fuel and consumed with said fuel as said engine is operated or (ii) being combined with the exhaust gas from said engine and removed from said  
20 engine with said exhaust gas; and

(D) adding an additional amount of said low-sulfur consumable lubricating oil composition to said engine to replace said removed part of said low-sulfur consumable lubricating oil composition.

19. The method of claim 18 wherein the combination of said fuel  
25 composition and said low-sulfur consumable lubricating oil composition formed in step (C) is comprised of 0.01% to 5% by weight of said low-sulfur consumable lubricating oil composition.

20. The method of claim 18 wherein during step (C) said removed part of said low-sulfur consumable lubricating oil composition is  
30 introduced into said fuel composition in the fuel tank, fuel return line, fuel injectors, intake manifold, positive crankcase ventilation system, exhaust gas recirculation system, or air intake system of the engine.

21. The method of claim 18 wherein said removed part of said low-sulfur consumable lubricating oil composition is combined with said exhaust gas upstream of said exhaust gas aftertreatment device.

5 22. The method of claim 18 wherein the engine is a compression ignition engine.

23. The method of claim 18 wherein said fuel is a diesel fuel composition.

24. The method of claim 18 wherein said fuel composition is a low-sulfur diesel fuel composition.

10 25. The method of claim 18 wherein said engine is a spark ignition engine.

26. The method of claim 18 wherein said fuel is a gasoline fuel composition.

15 27. The method of claim 18 wherein said fuel is an unleaded gasoline fuel composition.

28. The method of claim 18 wherein said fuel is a gasoline fuel composition having a sulfur content of up to 300 ppm.

29. The method of claim 18 wherein said fuel is a gasoline fuel composition having a chlorine content of no more than 10 ppm.

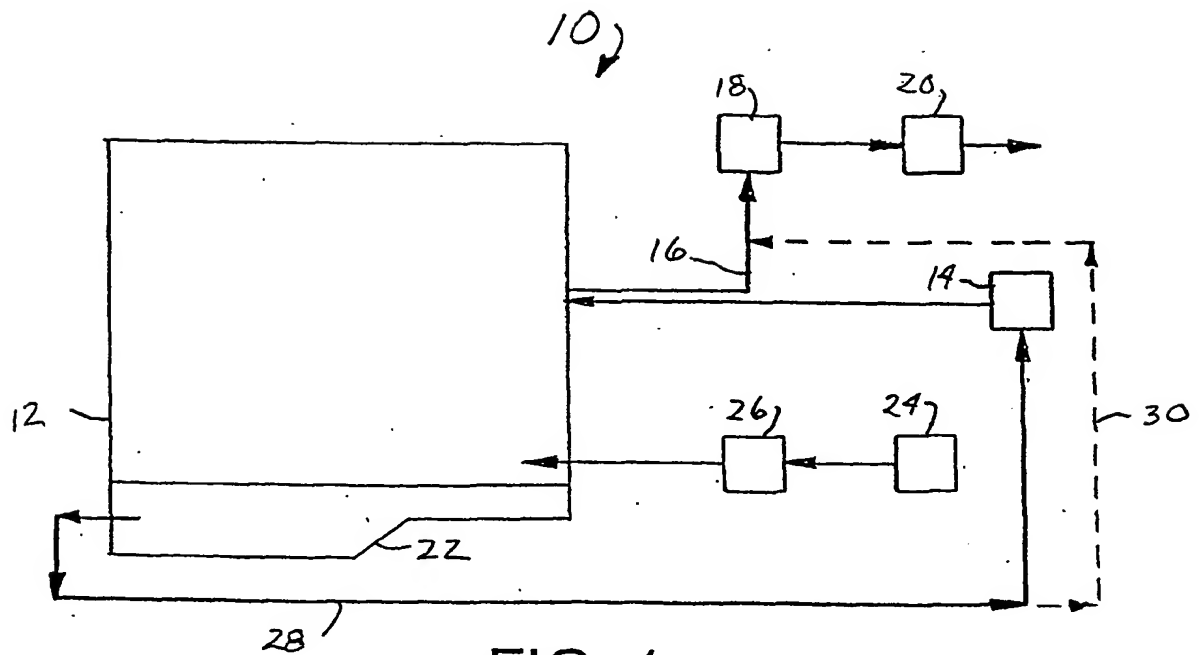


FIG. 1

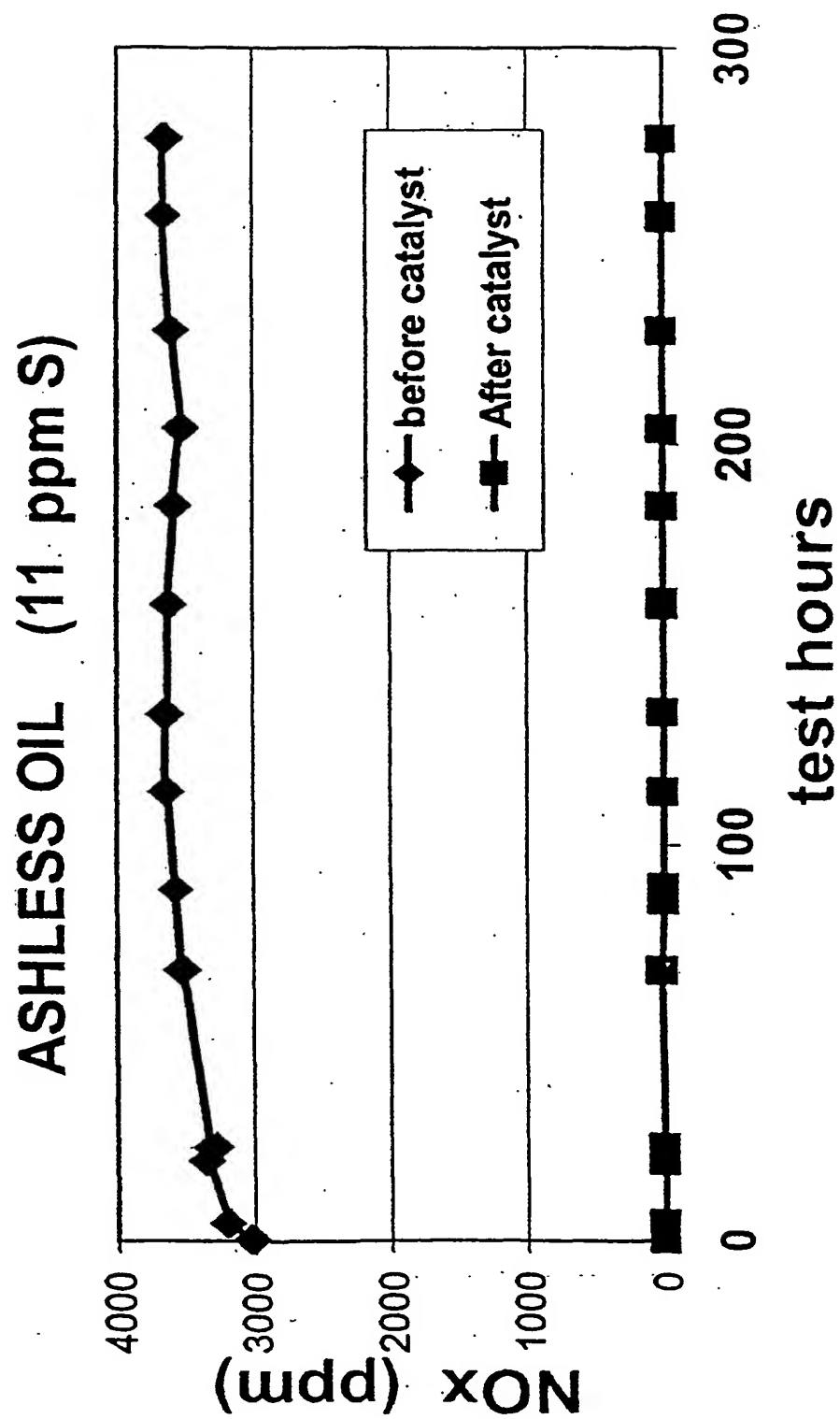


FIG. 2

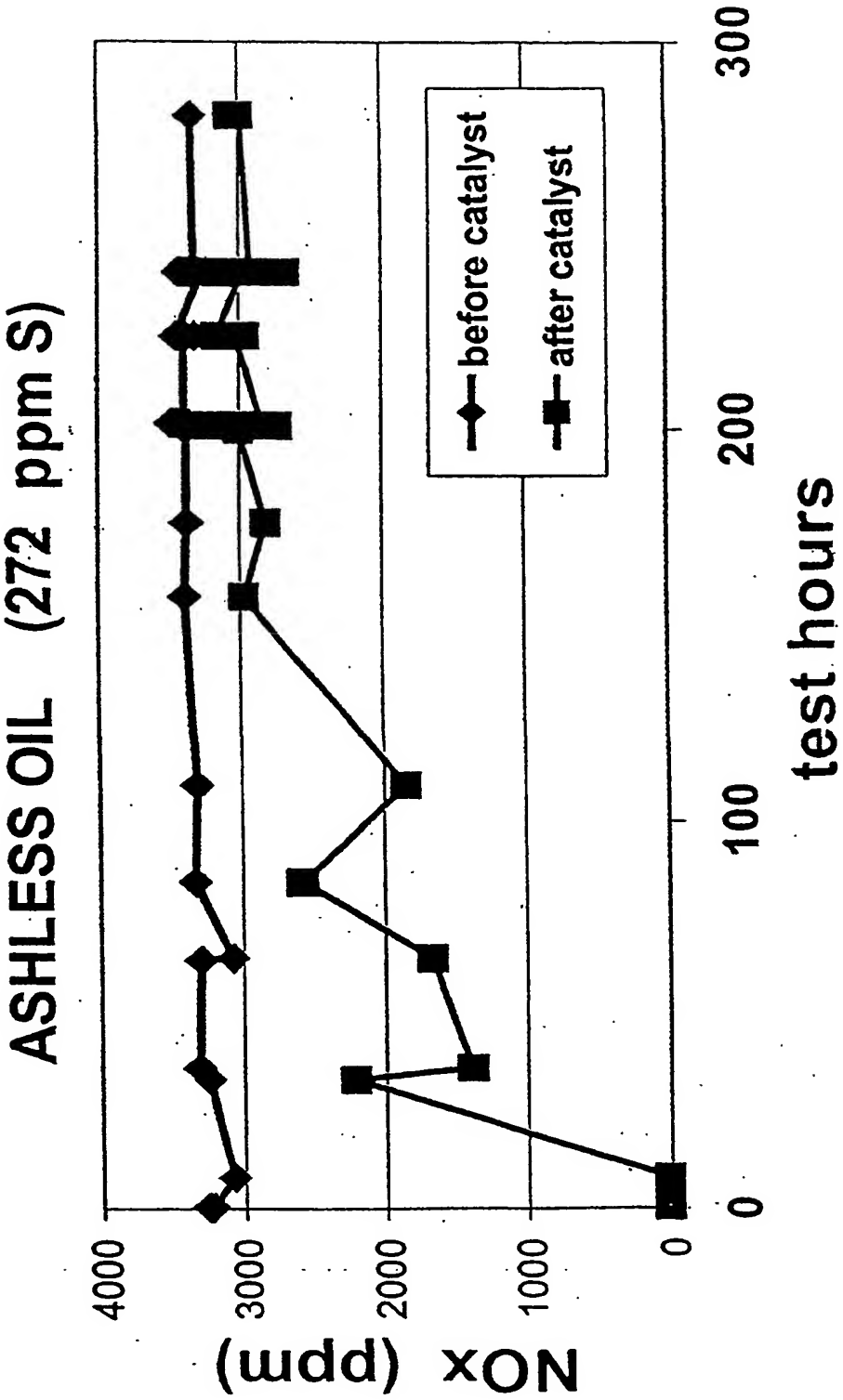


FIG. 3



## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/US 01/24820

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C10M171/00 C10M169/04 F01M11/04 F01N3/20 //C10N30:00,  
C10N40:25

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C10M F01M F01N

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Y	column 6, line 50 - column 8, line 45; example 1	3,5, 18-29
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

19 February 2002

Date of mailing of the international search report

27/02/2002

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## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/US 01/24820

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 93 03126 A (EXXON CHEMICAL PATENTS INC) 18 February 1993 (1993-02-18) page 2, paragraph 2 - paragraph 3 page 14, paragraph 4 page 27, paragraph 4 -page 28, paragraph 2 page 4, paragraph 1 - paragraph 2 -----	3,5
Y	US 5 555 858 A (KATOH MASAHIKO) 17 September 1996 (1996-09-17) column 10, line 30 -column 11, line 17; figures 10,15 -----	18-29
Y	US 5 720 249 A (JOHNSON JR JOHN L ET AL) 24 February 1998 (1998-02-24) column 2, line 42 - line 58; figure 1 -----	18-29

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